



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2332-041
Job Sheet 180359



Part No: D2332-041

Job Qty: 8 ea

Part Name: Lid Prop Assembly 6.69"



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Due Date: 7/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1, IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF IPP Rev:C 08-06-02 add comment DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	7/12/18	7/12/18	0.00	0.00	Start Up Small Fab		SMB
100	Small Fab	8 pcs	7/12/18	7/12/18	0.32	2.50	Small Fab		SMB
110	Brake NC	8 pcs	7/12/18	7/12/18	0.00	0.91	Brake NC 3		SMB
120	Small Fab	8 pcs	7/12/18	7/12/18	0.00	2.50	Small Fab		SMB
130	QC	8 pcs	7/12/18	7/12/18	0.00	0.00	QC5		38
140	Large Fab	8 pcs	7/12/18	7/12/18	0.00	1.99	Large Fab 1		38
150	QC	8 pcs	7/12/18	7/12/18	0.00	0.00	QC9		38
160	QC	8 pcs	7/12/18	7/12/18	0.00	0.00	QC5		38
170	Small Fab	8 pcs	7/12/18	7/12/18	0.00	2.50	Small Fab		38
180	QC	8 pcs	7/12/18	7/12/18	0.00	0.00	QC5		38
190	Packaging	8 pcs	7/12/18	7/12/18	0.00	0.00	Packaging3	FAD01	JUL 27 2018
200	QC21-SA	8 Ea	7/12/18	7/12/18	0.00	0.00	QC21		JUL 27 2018

Part Op 100 - 1- Cut D2332-7 and D2332-5 to lenght as per dwg D2332. 2- Cut D2332-11 using 1/2" S.S tubing 7.735" long. 3- Descriptions: Deburr.

110 - Punch and form D2332-11 to lenght as per dwg D2332 using DT8012 (need 2 per ass'y)

120 - 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no forein objects inside tube

140 - Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y) *****ensure nothing is inside of tube before welding***** S.S Rod batch:

170 - 1- Tumble 2- Assemble as per dwg D2332

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R.250	304 SS Round bar .250	.8000 ft (.1 ea)	90-Start up Operation	5035382
M304TR1.000W.049	304 Round Tube 1.00 X .049W	3.4400 ft (.43 ea)	90-Start up Operation	f125230
M304TR0.500W.035	304 Round Tube .500 X .035W	10 ft (1.25 ea)	110-Brake NC	506002
AN4-4A	Bolt	8 Ea (1 ea)	170-Small Fab	5044315
MS21042L4	Nut	8 Ea (1 ea)	170-Small Fab	5089365
NAS1149D0416J	Washer	24 Ea (3 ea)	170-Small Fab	5077157
				f m 131511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R.250	1	13	0

110-Brake NC	M304TR1.000W.049	3	9	0
170-Small Fab	M304TR0.500W.035	10	333	0
	AN4-4A	8	46	0
	MS21042L4	8	2,308	0
	NAS1149D0416J	24	2,986	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lid Prop Assembly	5.000Inches $\pm$ 0.030	5.030 4.970		
2	Lid Prop Assembly	1.250Inches $\pm$ 0.010	1.260 1.240		
3	Lid Prop Assembly	6.690Inches $\pm$ 0.010	6.700 6.680		

Plex 7/5/18 10:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Rework		Cross tube		Water Jet	
NCR No. _____		Scrap		Small Fab		Prod. Eng. Coord.	
Date: _____	Step #: _____	Use-as-is		Thermoforming		Rec/Store/Packaging	
Description Work Order: _____		Suspected Unapproved		Large Fab		Supplier	
							Engineering
							Quality
							Other
							MRB (QS1042) Approval
							Completed By
							Lead hand / Supervisor Approval Verification
							QC / QA Coordinator Approval

Container No: S093306
Part: D2332 - 041
Job No: 180359
Serial No/Batch: S093306
Revision: _____
Inspector: _____
Exp Date: _____
Instructions: _____

Date: 07/18/18

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Root Cause		Other	
Environment	No Re-verification	Positioned Wrong	
Design	Operator	Outside Dimensions	
Doc/Data	Offset/Setup	Over/Under tolerance	
Equip/Tooling	Supplier	Part Incorrect	
Handling/Pre	Training	Part Lost/Missing	
Material	Use for Testing	Part Moved	
Internal Transport	Poor Information	Drawing	
Tribal Knowledge	Rushing	Finish	
LOA	Product Improvement	Misread	
Substation	Process Improvement	Turning Sequence	
Past Expiry Date	Manufacturing Process		
Misidentified	Past Due		

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